

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80991

March-06-12 9:17:51 AM

80991

Page 2

Item ID: D2662-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, LH In 206

Start Date: 06/03/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80991

March-06-12 9:17:51 AM

80991

Page 3

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 06/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating W121134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 7:30 OVENTEMPERATURE: 320 OF FINISH TIME: 8:00	0.00				20 X	0		M-L 12/04/25
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				20	0		BL 12-4-25
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 845 Memo	0.00							8012-01-26 12/04/25 1120425 →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80991

March-06-12 9:17:51 AM

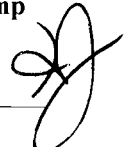
80991

Page 4

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, LH In 206
Start Date: 06/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 20/03/2012 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/4/25 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 9:17:56 AM

Page 1

Work Order ID: 80991

80991

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	63.0000	1	20			

D6101-001

Saddle Billet

**

36 12/04/12

Location	Loc Qty	Loc Code
MAT040	3	
69677	2	
76836	1	
MAT045	60	
79586	60	
81923		

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80991
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.613	3.616	3.615	3.616	3.616
B	0.256	0.263		.258	.257	.257	.257	.257
C	0.315	0.322		.317	.315	.315	.315	.315
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.681	1.679	1.679	1.679	1.679
F	0.100	0.140		.122	.120	.120	.120	.120
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.490	2.494	2.494	2.494	2.494
J	1.313	1.343		1.327	1.326	1.326	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.132	1.136	1.136	1.136	1.136
N	0.100	0.180		.133	.134	.134	.134	.134
O	0.100	0.145		.130	.130	.130	.130	.130
P	0.240	0.260		.252	.252	.252	.252	.252
Q	0.677	0.697		.689	.690	.690	.690	.690
R	0.540	0.560		.550	.549	.548	.550	.548
S	0.912	0.932		.922	.921	.921	.921	.921
T	0.787	0.807		.798	.798	.798	.798	.798
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.509	.500	.500	.500	.500
X	0.312	0.319		.313	.313	.313	.313	.313
Y	0.990	1.010		.992	.995	.995	.995	.995
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.502	.501	.501	.502
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.130	.136	.136	.136	.136
AE	0.235	0.240		.238	.238	.238	.238	.238
AF	0.510	0.515		.512	.511	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
AH								
AI								

QC8 JL/12-04-24

DART AEROSPACE LTD		Work Order:	80991
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: SK	Date: 12/04/23
Audited by: SJ	Date: 12/04/24
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD				Work Order: 80991	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	27	28	49	510
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.315	.315	.315	.315	.315
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.135	.135	.135	.135	.135
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.495	2.495	2.495	2.495	2.495
J	1.313	1.343		1.327	1.327	1.327	1.327	1.327
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.137	1.137	1.137	1.137	1.137
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145		.130	.130	.130	.130	.130
P	0.240	0.260		.252	.252	.252	.252	.252
Q	0.677	0.697		.688	.688	.688	.688	.688
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.921	.921	.921	.921	.921
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.313	.313	.313	.313	.313
Y	0.990	1.010		.994	.994	.994	.994	.994
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.135	.135	.135	.135
AE	0.235	0.240		.238	.238	.238	.238	.238
AF	0.510	0.515		.511	.512	.512	.511	.511
AG	0.100	0.120		.110	.110	.110	.110	.110
AH								
AI								

QC 2 -

QC8 - JL 12-04-24
FK 12/04/25

DART AEROSPACE LTD		Work Order:	80991
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.315	.315	.315	.315	.315
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.120	.120	.120	.120	.120
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.495	2.495	2.495	2.495	2.495
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.137	1.137	1.137	1.137	1.137
N	0.100	0.180		.133	.133	.133	.133	.133
O	0.100	0.145		.130	.130	.130	.130	.130
P	0.240	0.260		.252	.252	.252	.252	.250
Q	0.677	0.697		.690	.690	.690	.690	.690
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.002	6.002	6.002	6.002	6.002
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.502	.500	.502	.502	.502
X	0.312	0.319		.313	.313	.313	.313	.313
Y	0.990	1.010		.995	.995	.995	.995	.995
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.501	.501	.501	.501
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.135	.135	.135	.135
AE	0.235	0.240		.238	.238	.238	.238	.238
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
AH								
AI								

QC 2 -

QC 8 - SK 120424
FK 12/04/25

DART AEROSPACE LTD				Work Order: 80991	
Description: 206 Saddle, Inboard, Left side				Part Number: D2662-1	
Inspection Dwg: D2662 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

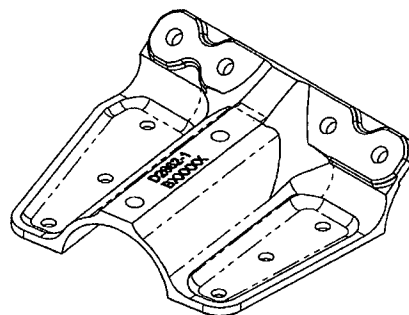
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	217	218	419	520
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.120	.120	.120	.120	.120
G	0.210	0.230		.223	.223	.223	.223	.223
H	0.615	0.685		.680	.680	.680	.680	.680
I	2.470	2.510		2.495	2.495	2.495	2.495	2.495
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.137	1.137	1.137	1.137	1.137
N	0.100	0.180		.133	.133	.133	.133	.133
O	0.100	0.145		.130	.130	.130	.130	.130
P	0.240	0.260		.252	.252	.252	.252	.252
Q	0.677	0.697		.688	.688	.688	.688	.688
R	0.540	0.560		.550	.550	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.001	6.001	6.001	6.001	6.001
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.501	.501	.501	.501	.501
X	0.312	0.319		.313	.313	.313	.313	.313
Y	0.990	1.010		.994	.994	.994	.994	.994
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.501	.501	.501	.501	.501
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.135	.135	.135	.135	.135
AE	0.235	0.240		.238	.238	.238	.238	.238
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
AH								
AI								

QC 2 -

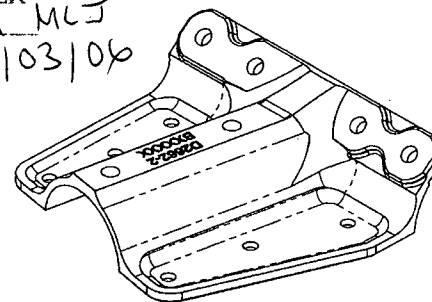
QC 8 - SL 12-04-24
FK 12/04/25

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 80991 MCT
 12/03/06



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
 2011-11-16
 NY

REV.	DESCRIPTION	BY	DATE
E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25

DESIGN	GP	DART AEROSPACE USA, INC.	
DRAWN	GP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. E
MFG. APPR.	AS	D2662	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CHAMFER 0.050X45°
AROUND SURFACE
2 PL

4.632

3.826

4.642

Ø0.257
6 PL

Ø0.316
2 PL

1.00

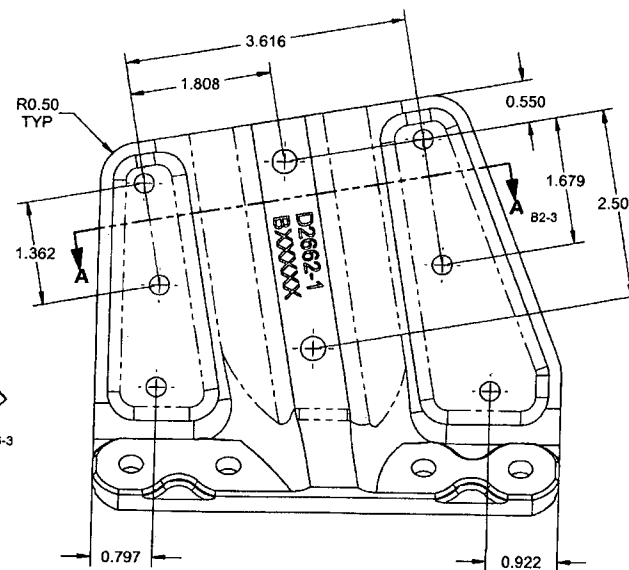
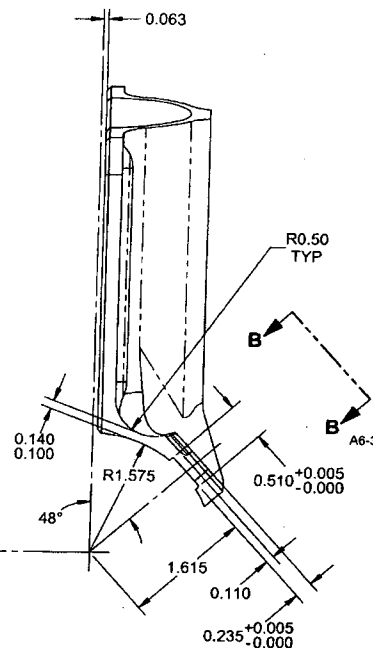
0.687

1.571
REF

E

80°

2.727



RELEASE
2011-11-16

1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D8101-001 SADDLE BILLET

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010

7) WEIGHT: 0.66 lbs

DESIGN	<i>Q</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRINTED ON RECYCLED PAPER. NO OTHER CONTENTS OR THE COPYRIGHTS CONTAINED THEREIN ARE TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	<i>ASS</i>		SHEET 2 OF 2
CHECKED	<i>WJH</i>		SCALE
MFG. APPR.	<i>WJH</i>		NTS
APPROVED	<i>WJH</i>		
DE APPR.	<i>WJH</i>		
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

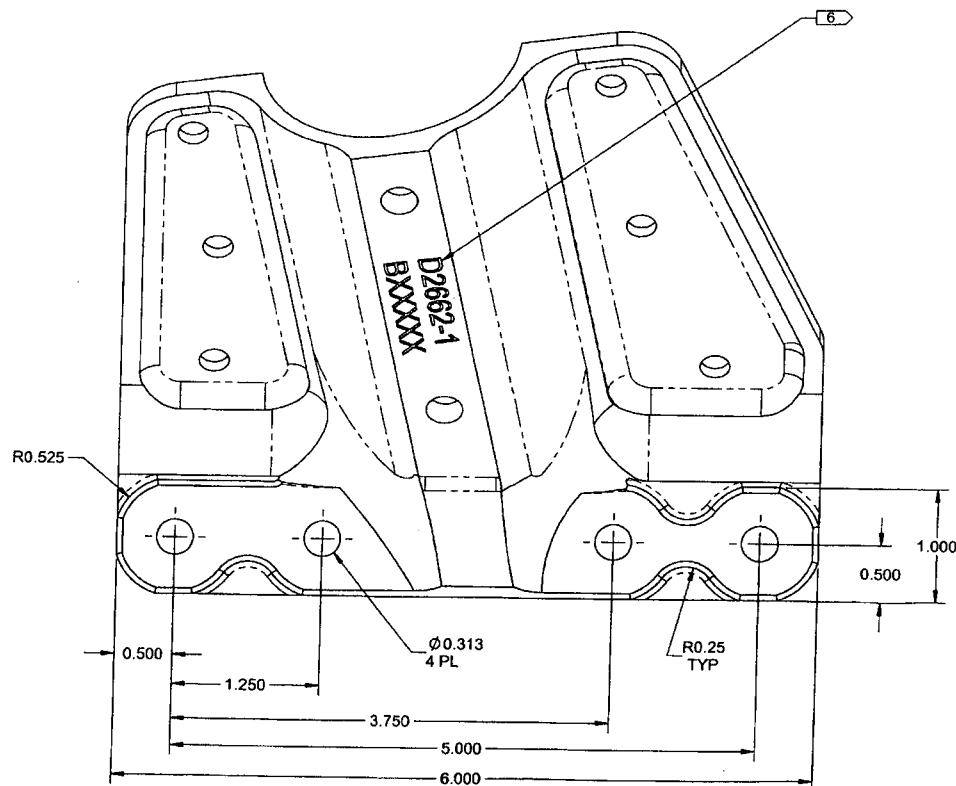
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

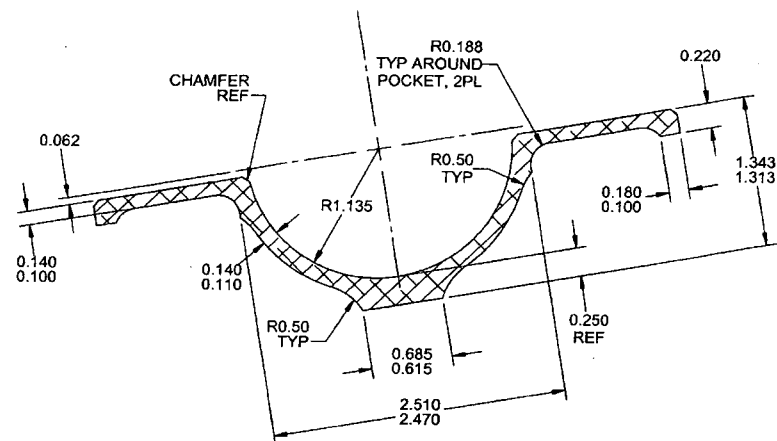
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80991



VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ABS	DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SADDLE, INSIDE	SCALE
DE APPR.			NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

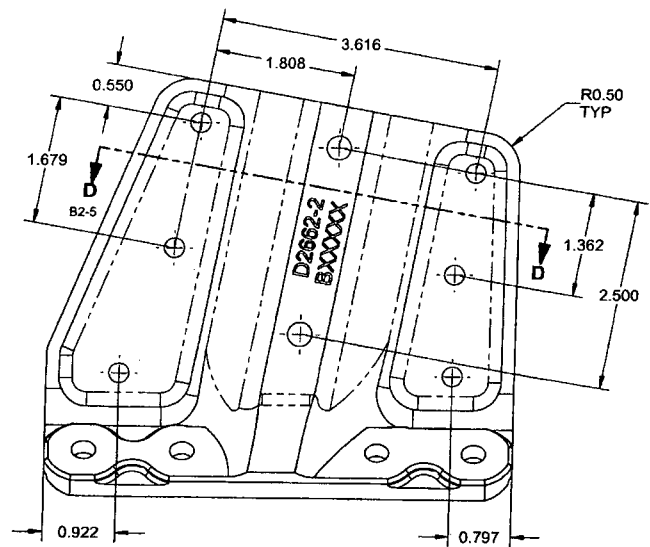
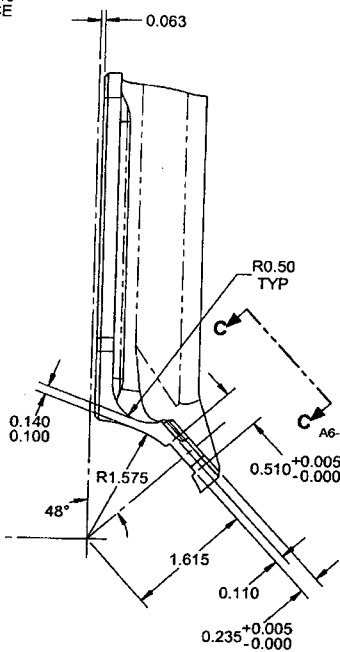
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Technical drawing of a mechanical part, likely a bracket or plate, showing dimensions and features.

Key dimensions and features:

- Top width: 4.642
- Total height: 4.632
- Base width: 2.727
- Left side height: 3.826
- Reference dimension: 1.571 REF
- Right side height: 1.00
- Bottom right dimension: 0.687
- Angle: 80°
- Chamfer: 0.050X45° AROUND SURFACE 2 PL
- Hole diameters: $\varnothing 0.257$ (6 PL) and $\varnothing 0.316$ (2 PL)



D2662-2 SADDLE, INSIDE, RH
1) MATERIAL: 7075 T3054 ALUMINUM

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

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DRAWN	<i>DB</i>		SHEET 4 OF 5
CHECKED	<i>AS</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

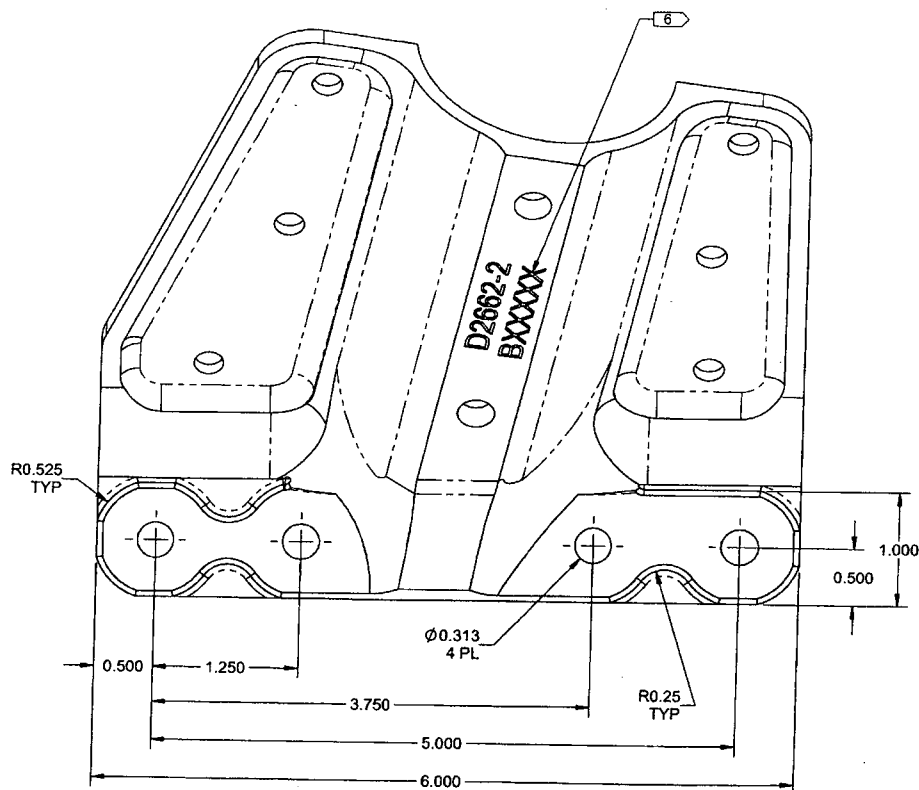
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

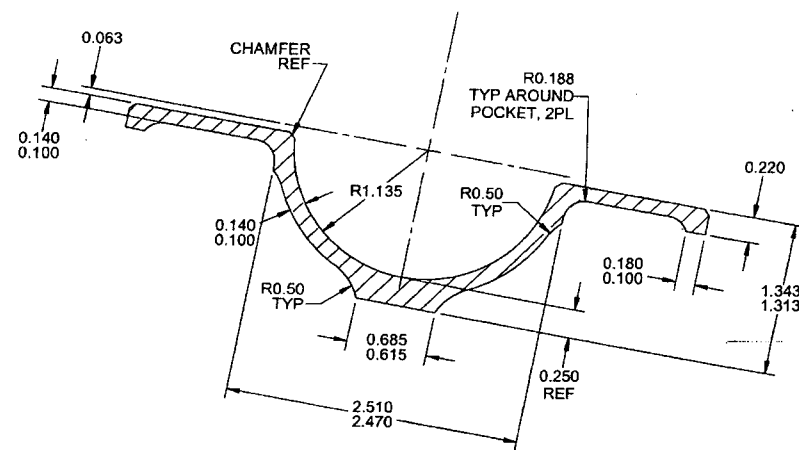
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW D-D
SCALE 1.5X
VIEW ROTATED



VIEW C-C
SCALE 1.5X

RELEASED
2011-11-16

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DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SADDLE, INSIDE	SCALE
DE APPR.			NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries